

Work Order ID 58359

May 4, 2010 10:49:33 AM



Page 1

Item ID: D3752-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame

Start Date: 5/04/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/05/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

BB
10/05/04

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240 F*
Time IN: *4:15 (10/05/04)*
Time OUT: *7:00 (10/05/05)*

BB
10/05/05

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3752 and folio (FTA022) using tool DT 8997

Dwg. Rev. C

Folio Rev. C

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB
10/05/05
X3

BB
10/05/05
X3

Wh.
10/05/05
X3

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1) Trim to Finished Dimensions

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

testes on frame on mock up

5/10/05/06

205 heli en saya Fit ok

(YB)

30
10/05/05
X3

30
10/05/05
X3

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location *251A*

0.00



Packaging

Memo

0.00

Packaging

10 5.7 S 3x

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/12 J

mf 10-3-7

Picklist Print

May 4, 2010 10:49:32 AM

Page 1

Work Order ID: 58359



Parent Item: D3752-1



Parent Item Name: Seat Frame

Start Date: 5/04/10

Required Date: 5/05/10

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

Start Qty: 4.00

Required Qty: 4.00

MLEXS.125-F60029-04

Purchased

No

100

sf

2,606.532

10.667



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

2606.5328

111710

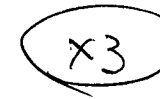
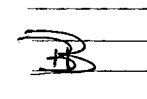
64

112585

195

114032

2347.5328



DART AEROSPACE LTD		Work Order:	58359
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

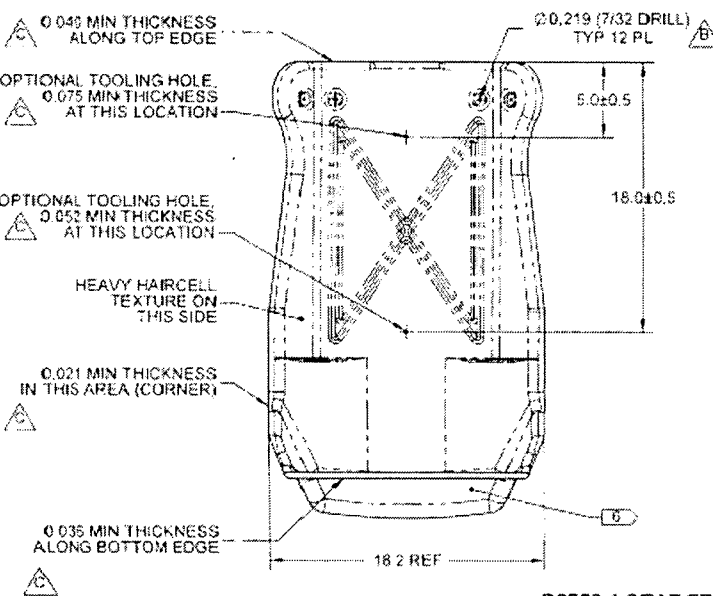
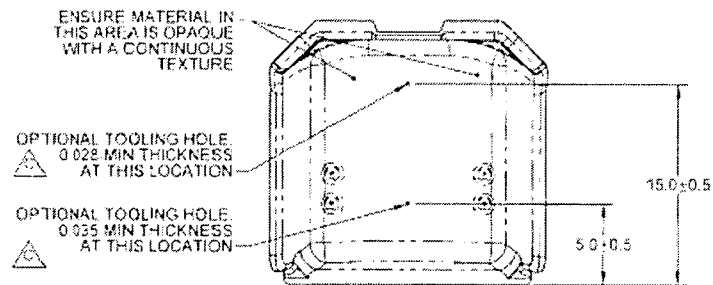
Measured by: <u>BB</u>	Date: <u>10/05/05</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.03 <u>0.024</u>	✓			
0.035	Min	<u>0.074</u>	✓			
0.040	Min	<u>0.058</u>	✓			
0.075	Min	<u>1.15</u>	✓			
0.052	Min	<u>1.02</u>	✓			
0.021	Min	<u>0.028</u>				
0.036	Min	<u>0.064</u>				

Measured by: <u>BB</u>	Date: <u>10/05/05</u>
Audited by: <u>OK</u>	Date: <u>10/05/05</u>
Prototype Approval:	Date:

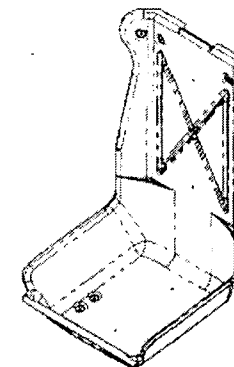
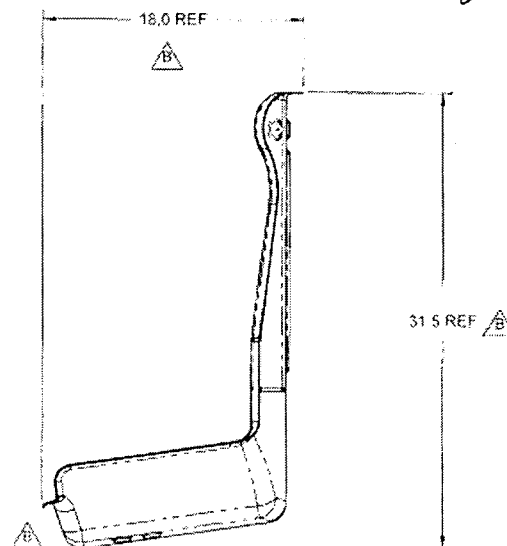
Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	<u>AK</u>



D3752-1 SEAT FRAME

NOTES

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 518 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N 'D3752-1' & B/N 'BXXXXX' USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8597 AND OSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD



RELEASED
Info 1970

U	REDUCE THICKNESS: 0.040 WAS 0.030 (IN C2-1); 0.035 WAS 0.100 (C4-1); 0.052 WAS 0.050 (B4-1); 0.051 WAS 0.050 (B5-1); 0.036 WAS 0.060 (A8-1); 0.028 WAS 0.035 (D8-1); 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D5-1).	CP	02.10.03
H	FRONT PORTION NOW SHORTER (B5-1); 16.3 WAS 19.5 (C4-1); 31.5 WAS 30.3 (B3-1); ADD 4 HOLES FOR THICKNESS MEASUREMENT (D3-1, D8-1).	CP	08.08.06
A	NEW ISSUE	CP	08.04.25
REV	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3752	REV. C
TITLE SEAT FRAME	SCALE NTS
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